

Work Order ID 83522

83522

Page 1

Thursday, April 19, 2012 10:28:52 AM

Item ID: D3675-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SLIDING DOOR BRACKET
 Start Date: 4/19/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: 2012/4/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(16)			
D3675	RevD								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3675								
304 - 040	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B12-5-19

B12-5-19

5/12/12

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: SLIDING DOOR BRACKET
Start Date: 4/19/2012 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/27/2012 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00				16			8/16/05/29
Brake NC	Form as per Dwg D3675 use DT9723								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				16			12/05/30
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:30								
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 3:00								

W12/279

16X ~~Q~~ 12/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D3675-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SLIDING DOOR BRACKET

Start Date: 4/19/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>51 Z36A</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

16x 6 M 120610g

16 500 12/06/05

12/6/5 JF
ME
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 19, 2012 10:29:00 AM

Work Order ID: 83522

83522

Parent Item: D3675-1

D3675-1

Parent Item Name: SLIDING DOOR BRACKET

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue 08-04-21 DD verified by:EC IPP Rev:B
11.01.11 as per dwg rev.C DD verified by:EC IPP Rev C 11.03.31
ECN 11-531 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	371.3609	0.121	1.273684	2		

M304S20GA

**

B(2-5-19

304/316 .040 Sheet

Location

Loc Qty

Loc Code

001	52.6444105	
121192	52.6444105	
MAT020	318.7165	
117933	27.3442	
118400	6.3723	
118964	30.2	
119346	29.8	
121380	225	

121380

(16)

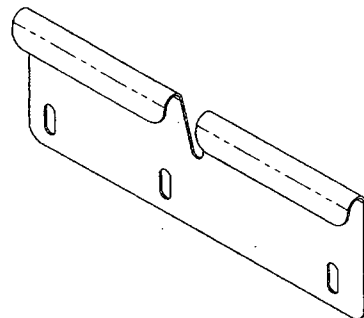
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

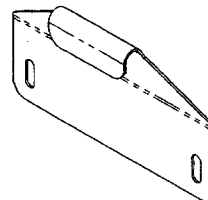
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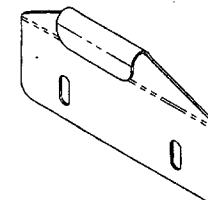
NOTE: Date & initial all entries



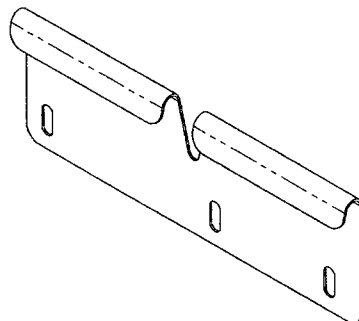
D3675-5 SLIDING DOOR BRACKET



D3675-1 SLIDING DOOR BRACKET



D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)



D3675-6 SLIDING DOOR BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83522

R12-04-19

RELEASED
2011-03-31

REV.	DESCRIPTION	BY	DATE
D	RE-DESIGNED D3675-5/-6/-5F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PAR11-79.	MB	11.03.21
C	ADD -5/-5F/-6 BRACKET	MB	10.12.17
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A'	NEW ISSUE	AJS	08.03.27
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3675 TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR) SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	A		
CHECKED	AJS		
MFG. APPR.	DS		
APPROVED	AP		
DE APPR.	AP	REV. D SHEET 1 OF 6	
DATE	11.03.21		

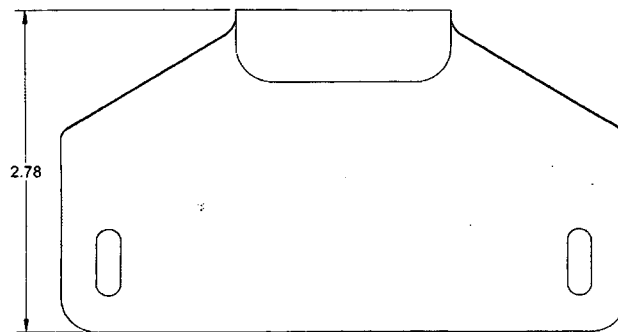
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

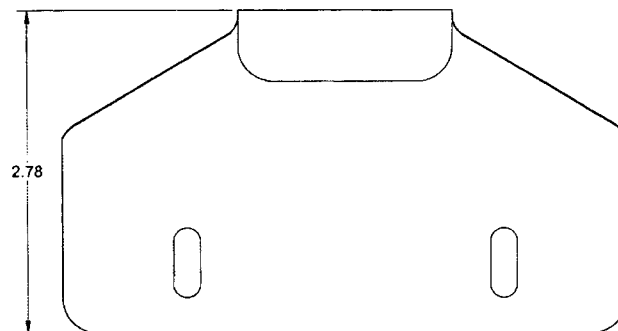
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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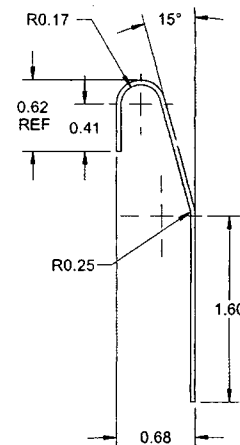
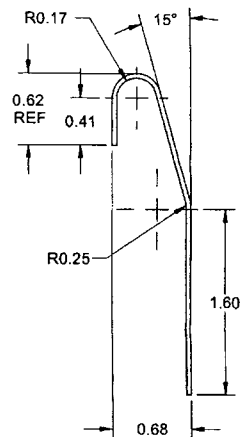
NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



83522

RELEASED
2011-03-31
JH

NOTES:

- 1) MATERIAL: SEE SHEET 5
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs EACH
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

DESIGN	ASIS	DART AEROSPACE LTD	
DRAWN	ASIS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASIS	DRAWING NO.	REV. D
MFG. APPR.	ASIS	D3675	SHEET 2 OF 6
APPROVED	ASIS	TITLE	SLIDING DOOR BRACKET
DE APPR.	ASIS	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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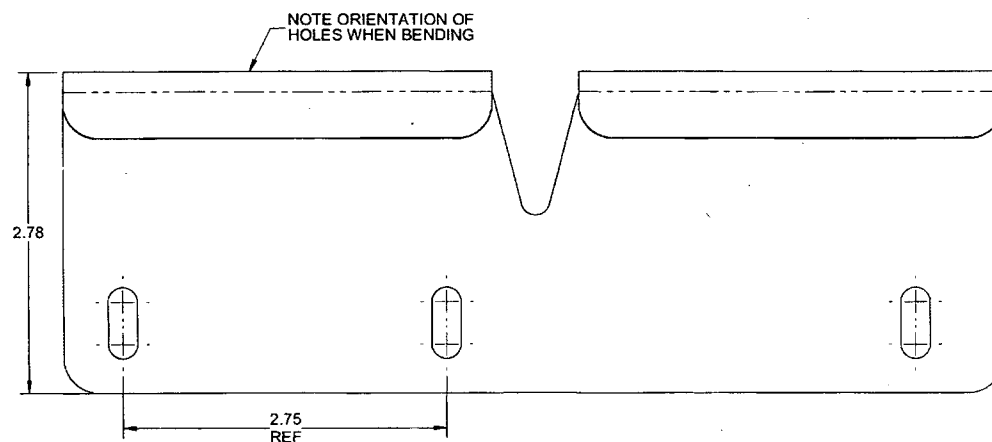
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D

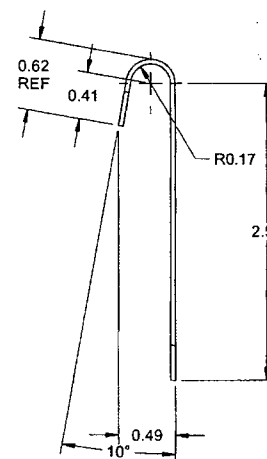
C

B

A



D3675-5 SLIDING DOOR BRACKET
(MAKE FROM D3675-5F)



83522

RELEASED
2011-03-30
MM

NOTES:

- 1) MATERIAL: SEE SHEET 8
- 2) FINISH: POWDER COAT GREY SANDETEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-5" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-5 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-3 BRACKET.

DESIGN	<i>AJS</i>	DART AEROSPACE LTD	
DRAWN	<i>AJS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AJS</i>	D3675	SHEET 3 OF 6
APPROVED	<i>AJS</i>	TITLE	SLIDING DOOR BRACKET
DE APPR.	<i>AJS</i>	(COMPOSITE DOOR)	SCALE
DATE	11.03.21		NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

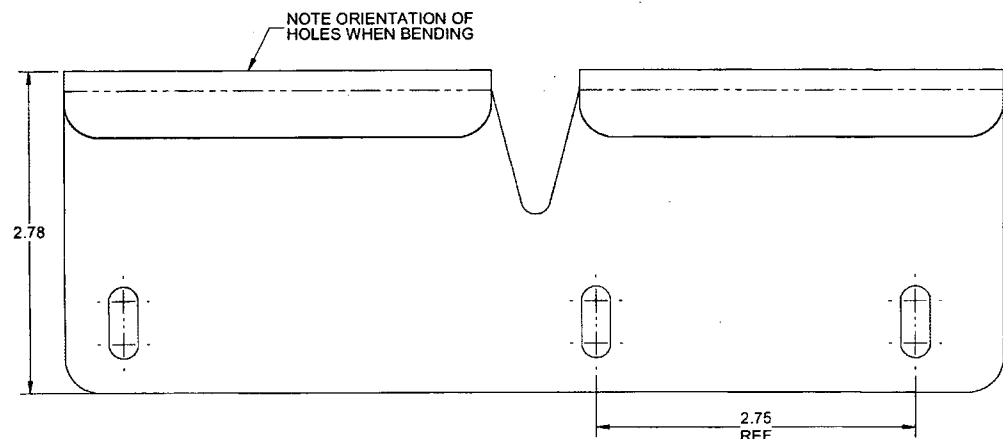
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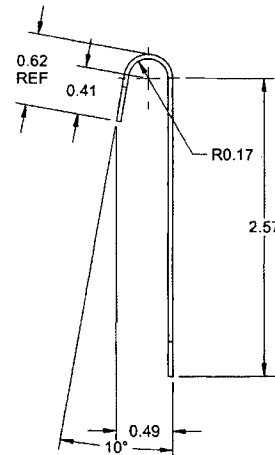
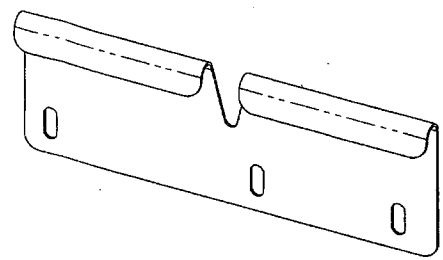
C

B

B



D3675-6 SLIDING DOOR BRACKET
(MAKE FROM D3675-SF)



83522

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: SEE SHEET 6
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-6" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.31 lbs EACH
- 8) THE D3675-6 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-4 BRACKET.

DESIGN	<i>ALS</i>	DART AEROSPACE LTD	
DRAWN	<i>ALS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO. D3675	REV. D
MFG. APPR.	<i>ALS</i>	SHEET 4 OF 6	
APPROVED	<i>ALS</i>	TITLE SLIDING DOOR BRACKET (COMPOSITE DOOR)	SCALE NTS
DE APPR.	<i>ALS</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	11.03.21	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

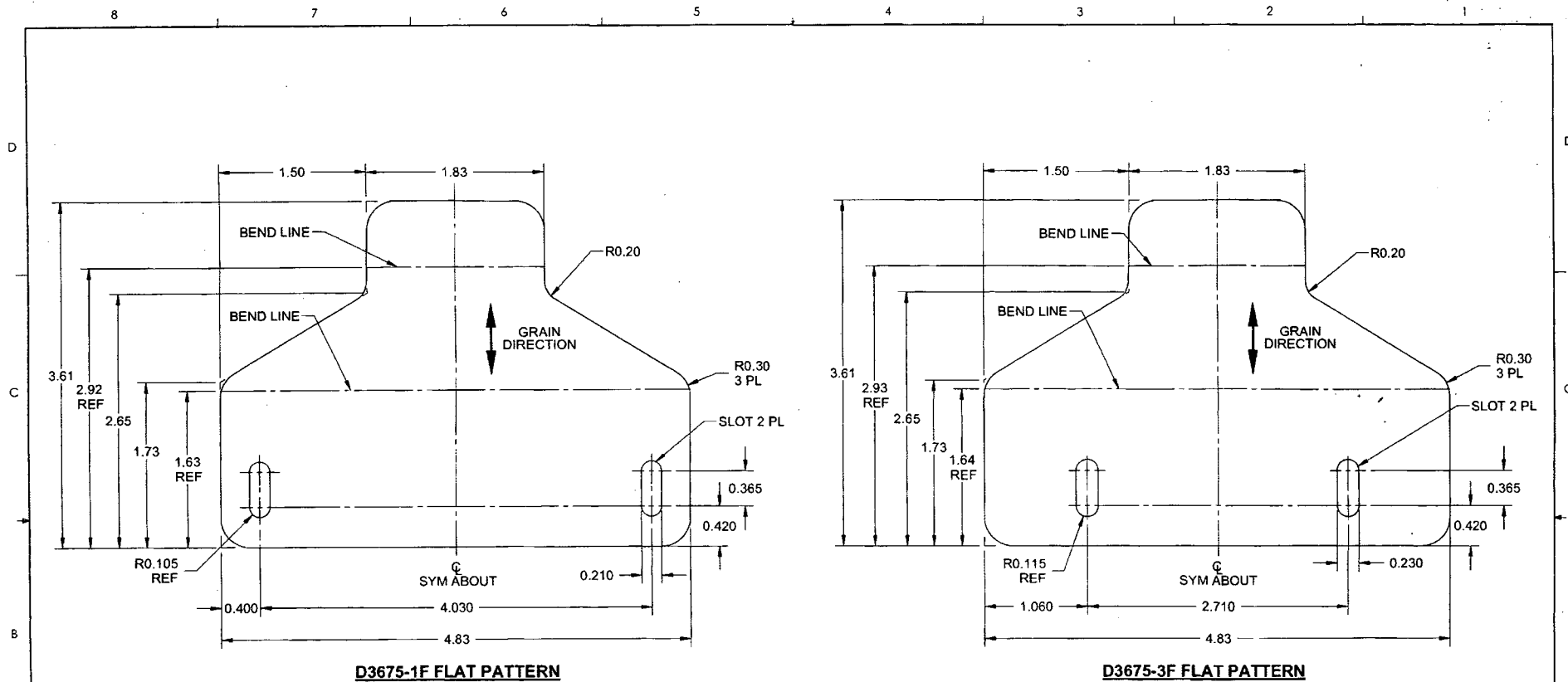
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



83522

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20G.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs EACH

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	N	D3675	SHEET 5 OF 6
APPROVED	MP	TITLE	SLIDING DOOR BRACKET
DE APPR.	#	(COMPOSITE DOOR)	SCALE
DATE	11.03.21	NTS	
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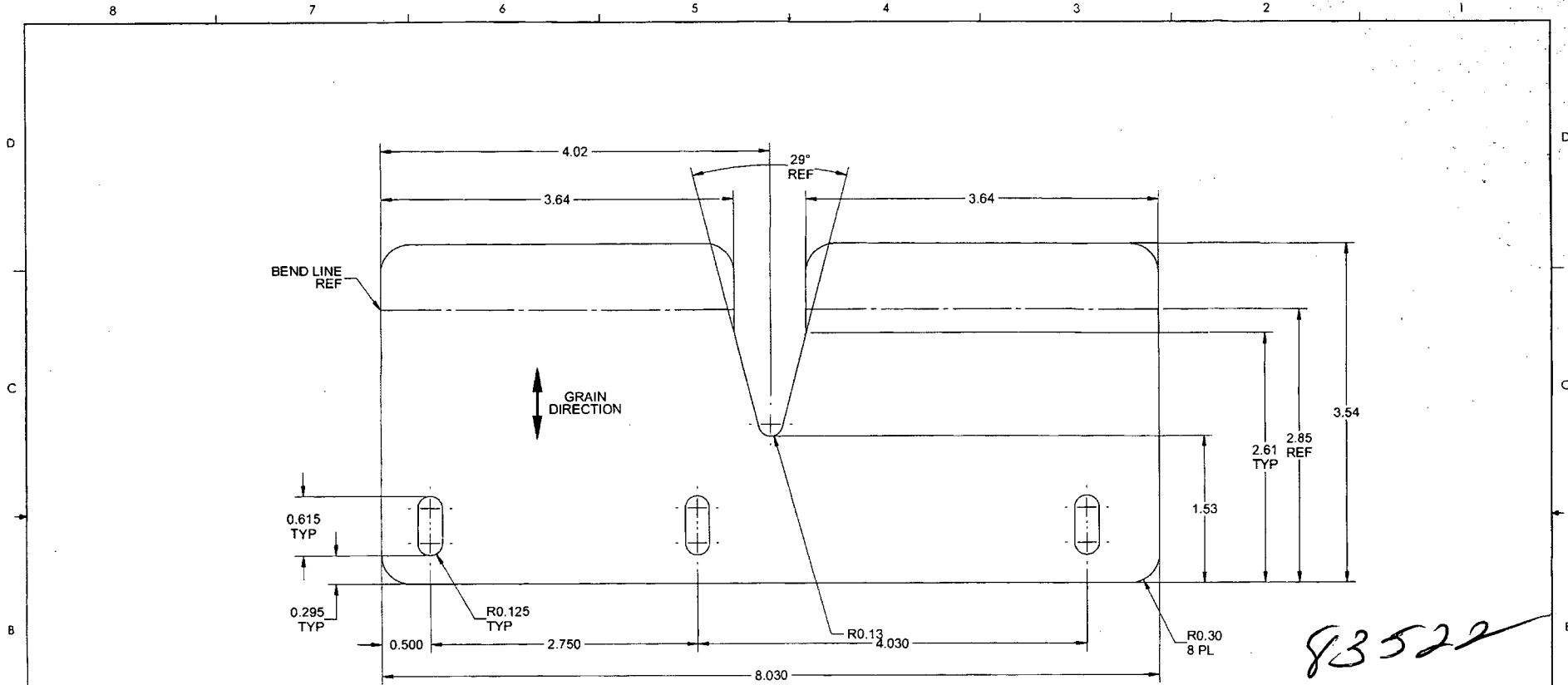
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NOTE: Date & initial all entries



D3675-5F FLAT PATTERN

83522

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D3675	SHEET 6 OF 6
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	SLIDING DOOR BRACKET (COMPOSITE DOOR)	NTS
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